

**Work Order ID 67260**

Monday, March 14, 2011 10:59:34 AM

*BLUES*

Page 1

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*CL*

Date:

*11/03/14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2933

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

*41*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

*11/3/29*

110

0.00



CONVENTIONAL MILLING MACHINE

*41*

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*11/3/29*

120

0.00



QC1- Inspect dimensions to dimension sheet

*41*

QC

Memo

0.00

Quality Control

*11/3/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 67260



Page 2

Monday, March 14, 2011 10:59:34 AM

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*OK 11/03/29*

*4*

*2*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*4*

*BR 11-3-30*

155

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

Spray Painting:  
prime grey B: 115967  
spray paint delfleet blue B: 115985  
clear delfleet B: 117113

*ml*

*11*

*04*

*07*

*(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67260**

Page 3

Monday, March 14, 2011 10:59:34 AM

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start

Approvals: Process Plan: 4 Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	<del>QC3</del> Inspect Part Finish <u>QC 14</u> Memo	0.00 0.00						<u>ET</u> <u>11-04-08</u> <u>(X4)</u>	
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>421</u> Memo	0.00 0.00						<u>11/4/11</u> <u>SL</u> <u>QJ</u>	
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>11/4/12</u> <u>JS</u> <u>W. 11.04.12</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, March 14, 2011 10:59:30 AM

Page 1

Work Order ID: 67260

Parent Item: D2933-1

Parent Item Name: Saddle LH In, 206



Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B000.06.26 New DWG rev (mpp 2069) ECU  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001  Saddle Billet		Manufactured	No			100	Each	56.0000	1	4		11/3/28	

Location

MAT40

Loc Qty

56

Loc Code

~~64777~~

66965

~~36~~

20

~~15~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	67260
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933	Rev: C	DSK:	Rev:
			Page 1 of 1

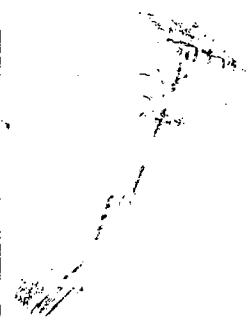
### FIRST ARTICLE INSPECTION DIMENSION SHEET

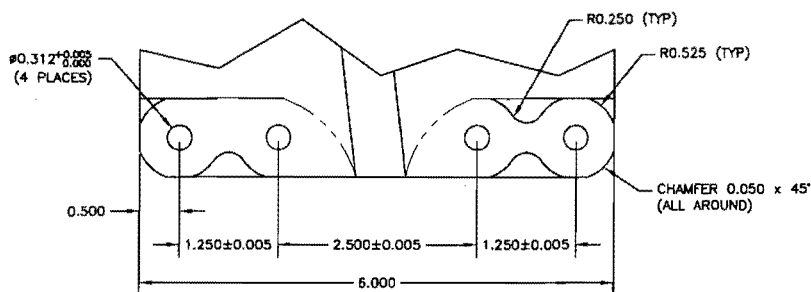
☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.135	.130	.130	.130	
B	0.100	0.140		.136	.132	.131	.131	
C	0.100	0.140		.130	.125	.125	.126	
D	0.210	0.230		.220	.220	.220	.220	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.510	.510	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.258	.258	.258	.258	
L	0.312	0.317		.314	.314	.314	.314	
M	0.235	0.240		.237	.238	.238	.236	
N	0.100	0.140		.110	.110	.110	.110	
O	0.540	0.560		.545	.548	.543	.547	
P	0.490	0.510		.498	.497	.497	.497	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.491	2.491	2.491	2.491	
S	0.240	0.270		.250	.250	.251	.250	
T	0.100	0.180		.135	.135	.135	.135	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.317	.317	.317	.317	
X	1.125	1.145		1.135	1.135	1.135	1.135	
Y	1.565	1.585		1.575	1.575	1.575	1.575	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: <i>SA</i>	Date: 11/3/29
Audited by: <i>cmf</i>	Date: 11/03/29
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	<i>DD</i>



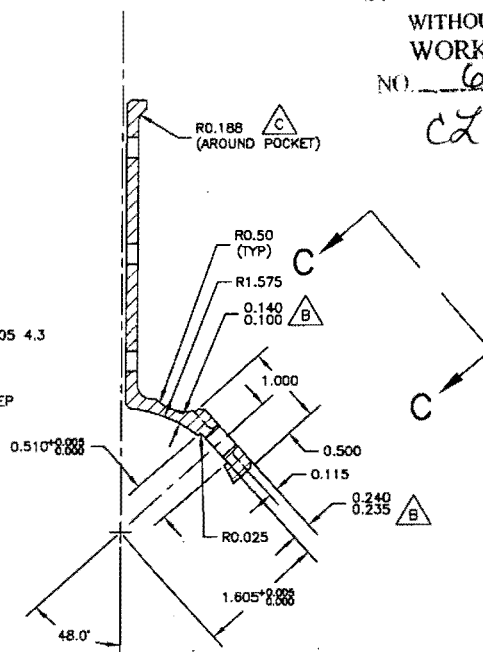


VIEW C-C

D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B

CHAMFER 0.050 x 45° AROUND  
THIS SURFACE (TYP 2 PLACES)

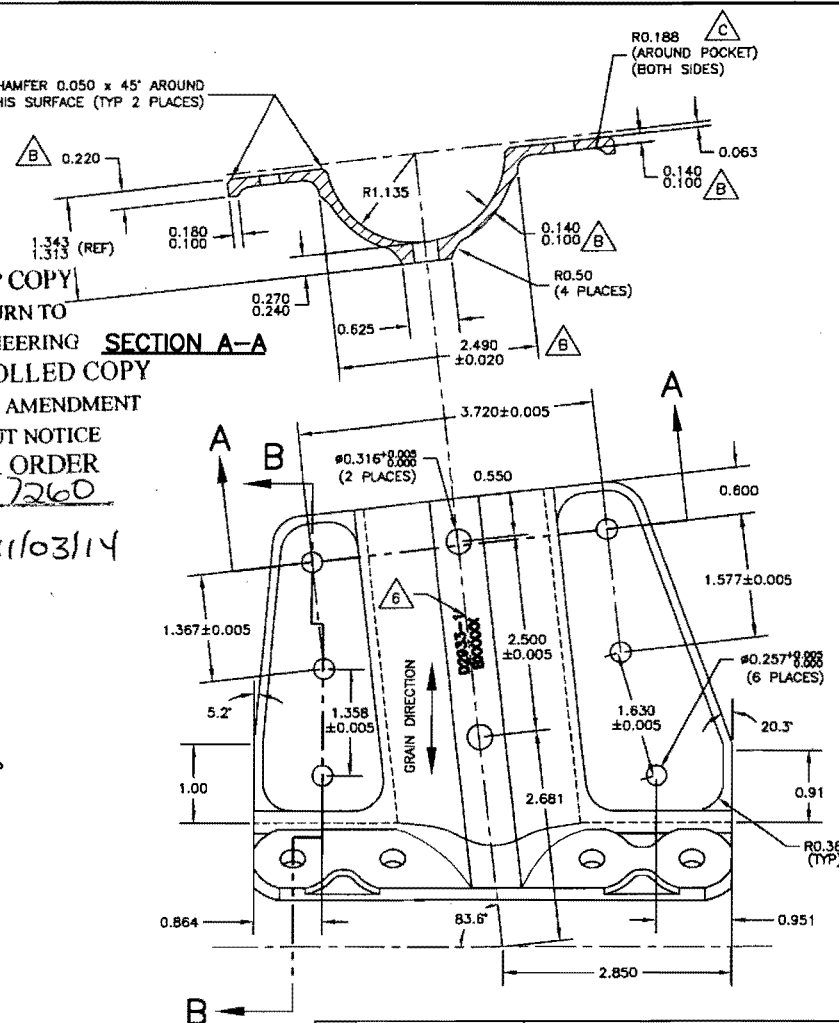
SHOP COPY  
RETURN TO

ENGINEERING SECTION A-A  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 67260

CZ110314



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		D2933
		SADDLE INSIDE

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**DART** DART AEROSPACE USA, INC.  
BELLINGHAM, WA

DRAWING NO. D2933

SHEET 1 OF 1

SCALE 2:3

07.02.12

